

Work Order ID 71613

Wednesday, July 06, 2011 3:27:48 PM



Page 1

Item ID:	D3929-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gusset Assembly					
Start Date:	7/6/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	7/12/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/07/06</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	A								

100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3929								
<u>304.125</u>	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B11-7-13

8

B11-7-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71613

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Item ID: D3929-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 7/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

Memo

8/6/13



140



Large Fab

Large Fab

Memo

Weld bushings D3907-1 as per dwg D3929

0.00

0.00

316L rod batch: M114549

Pl 11.07.18 pmb 11/07/08 (8)

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

Memo

11.07.18 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71613

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Page 3

Item ID: D3929-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 7/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC5- Inspect part completeness to step on W/O	0.00							
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QC

Memo

0.00

Quality Control

11.07.18 (8)

170	Identify as per dwg & Stock Location: <u>WAS</u>	0.00							
-----	--	------	--	--	--	--	--	--	--



Packaging

Memo

0.00

Packaging

P.B. 11/07/18 (8)

180	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--



QC

Memo

0.00

Quality Control

11/7/20

MF
11-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 3:27:45 PM

Page 1

Work Order ID: 71613

Parent Item: D3929-042

Parent Item Name: Gusset Assembly



Start Date: 7/6/2011

Required Date: 7/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	102.0000	0.45	2.842105			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		102							
				117494		102							
D3907-1 Bushing		Manufactured	No			130	Each	72.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				.WA		42							
				70673		42							
				WA005		30							
				65920		4							
				66090		26							

B11-7-13

68

117494

Pl 11-07-18

B 71533

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

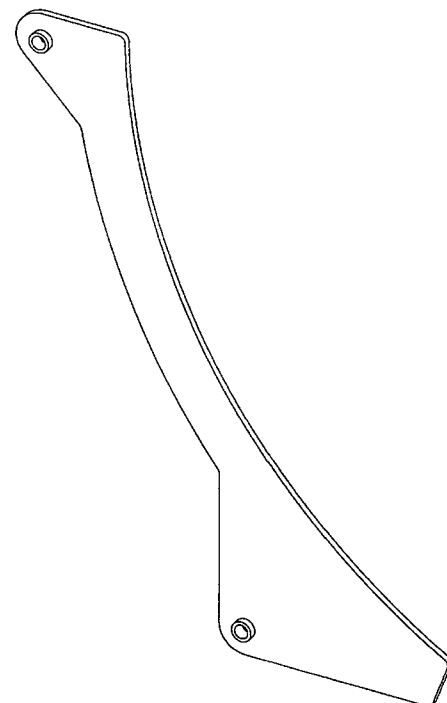
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

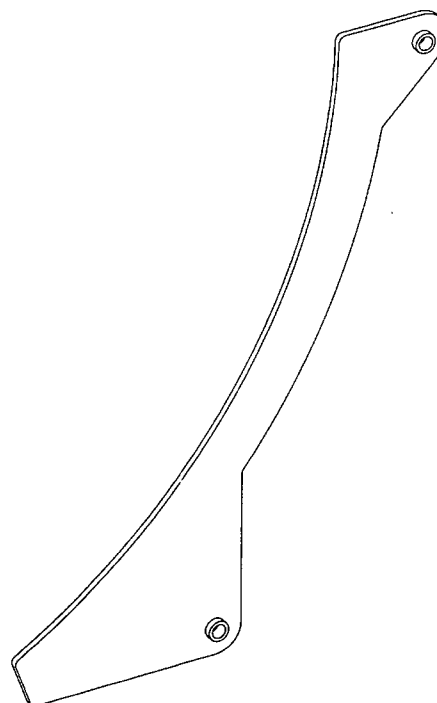
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
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UNCONTROLLED CO
SUBJECT TO AMENDMEN
WITHOUT NOTICE
WORK ORDER

NO. 71613

C211107106

RELEASED
3/24/12

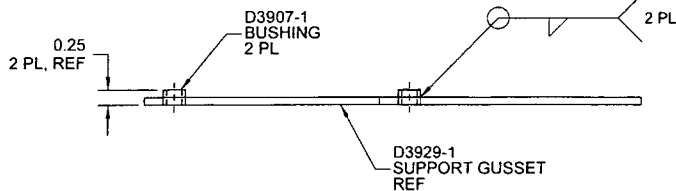
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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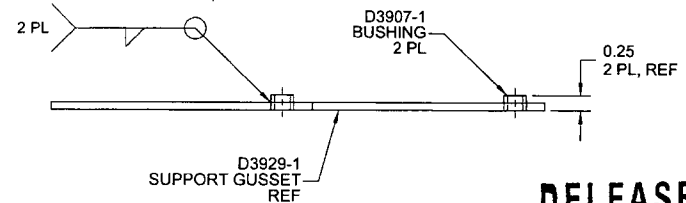
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WORK ORDER
NO. 71613

D3929-1
SUPPORT GUSSET
2 PL

D3929-1
SUPPORT GUSSET
2 PL



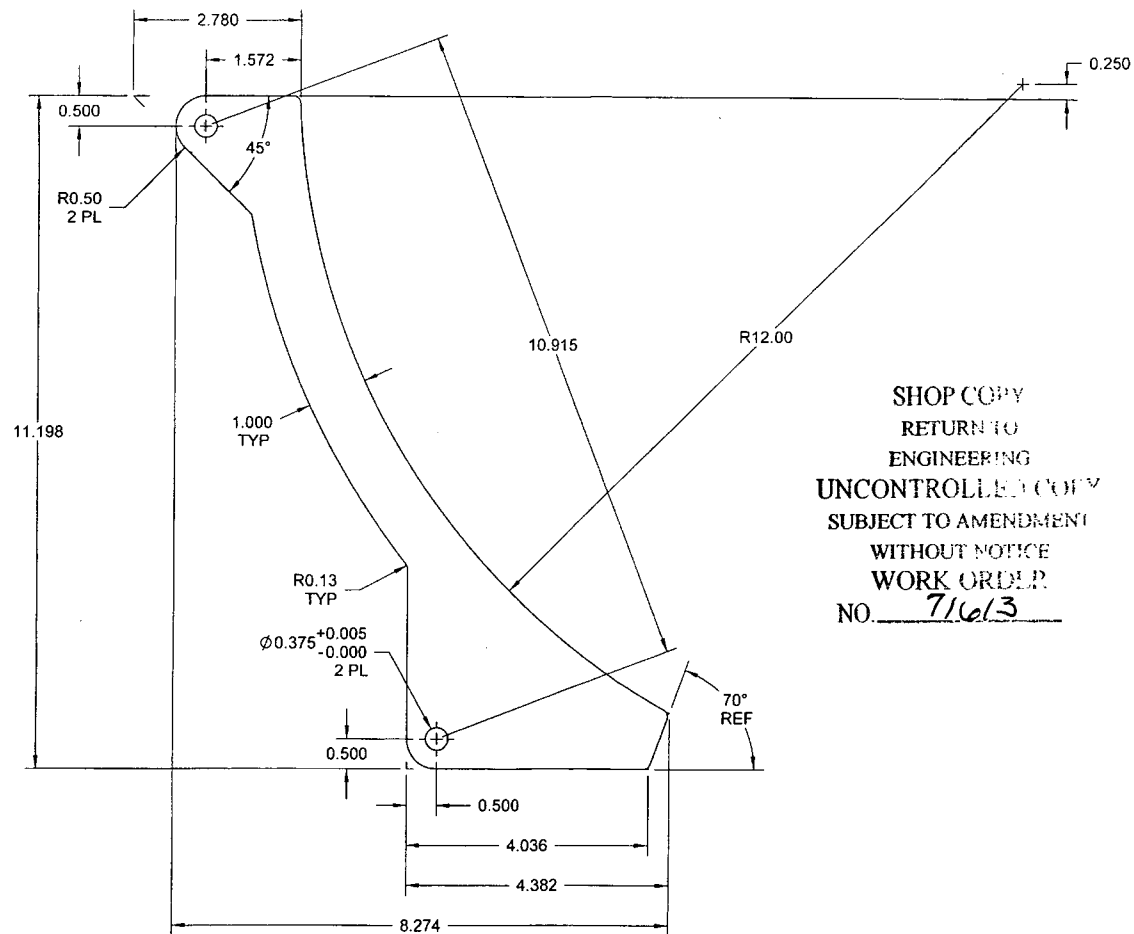
D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

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09/04/22 MD

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MFG. APPR.		SHEET 2 OF 3	
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NO. 71613

D3929-1 SUPPORT GUSSET

RELEASED
9/24/22

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

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CHECKED		DRAWING NO.	REV. A
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